

Date: Thursday, 2/7/2008 10:54:25 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	37285		Part Number	D2574		
Estimate Number	10534		Drawing Number	D2574 REV E		
P.O. Number			Project Number	N/A		
This Issue	2/7/2008	S.O. No.	Drawing Revision	E		
Prsht Rev.	NC		Material			
First Issue	/ /	Type	Due Date	Qty:	12	Um: Each
Previous Run	36325					
Written By						
Checked & Approved By	<u>JK</u> 08/02/07					
Comment	Est Rev: I As Per RevE 06-01-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	7075-T7351 8.25X5.0X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u>B31388</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>J728</u> Double check by: <u>JK</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No.2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/03/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/7/2008 10:54:26 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 37285

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

2F 08/03/18 (12)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

F1 08/03/18 (12)

7.0 POWDER COATING POWDER COATING



M 107005

(12)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

bk 08-03-19

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



HLJ

08-03-19 (X12)

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 433

8/3/19 scf (12)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

Do 08/03/20

Job Completion



u 08/03/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37285
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.006	8.001	8.004	8.003		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.502	.503	.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.571	.570	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.369	1.370		
N	2.495	2.505		2.500	2.501	2.500	2.499		
O	4.119	4.129		4.122	4.124	4.124	4.124		
P	0.115	0.135		.124	.125	.125	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.249	.251		
S	0.115	0.135		.126	.126	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.230	3.230	3.228		
V	0.230	0.250		.238	.239	.239	.238		
W	0.115	0.135		.130	.129	.132	.132		
X	0.307	0.312		.309	.309	.309	.309		
Y	0.760	0.765		.762	.766	.760	.760		
Z	0.352	0.372		.362	.364	.366	.366		
AA	0.470	0.530		.560	.560	.560	.560		
AB	0.615	0.635		.629	.629	.631	.631		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.248	.248	.247		
AE	1.500	1.520		1.512	1.513	1.512	1.512		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.265	.262	.266		
AH	0.240	0.260		.251	.249	.250	.249		
AI	2.000	2.020		2.002	2.003	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>Onf</i>	Audited by:	<i>RF</i>
Date:	<i>08/03/12</i>	Date:	<i>08/03/18</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>JLM</i>

DART AEROSPACE LTD	Work Order:	37285
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

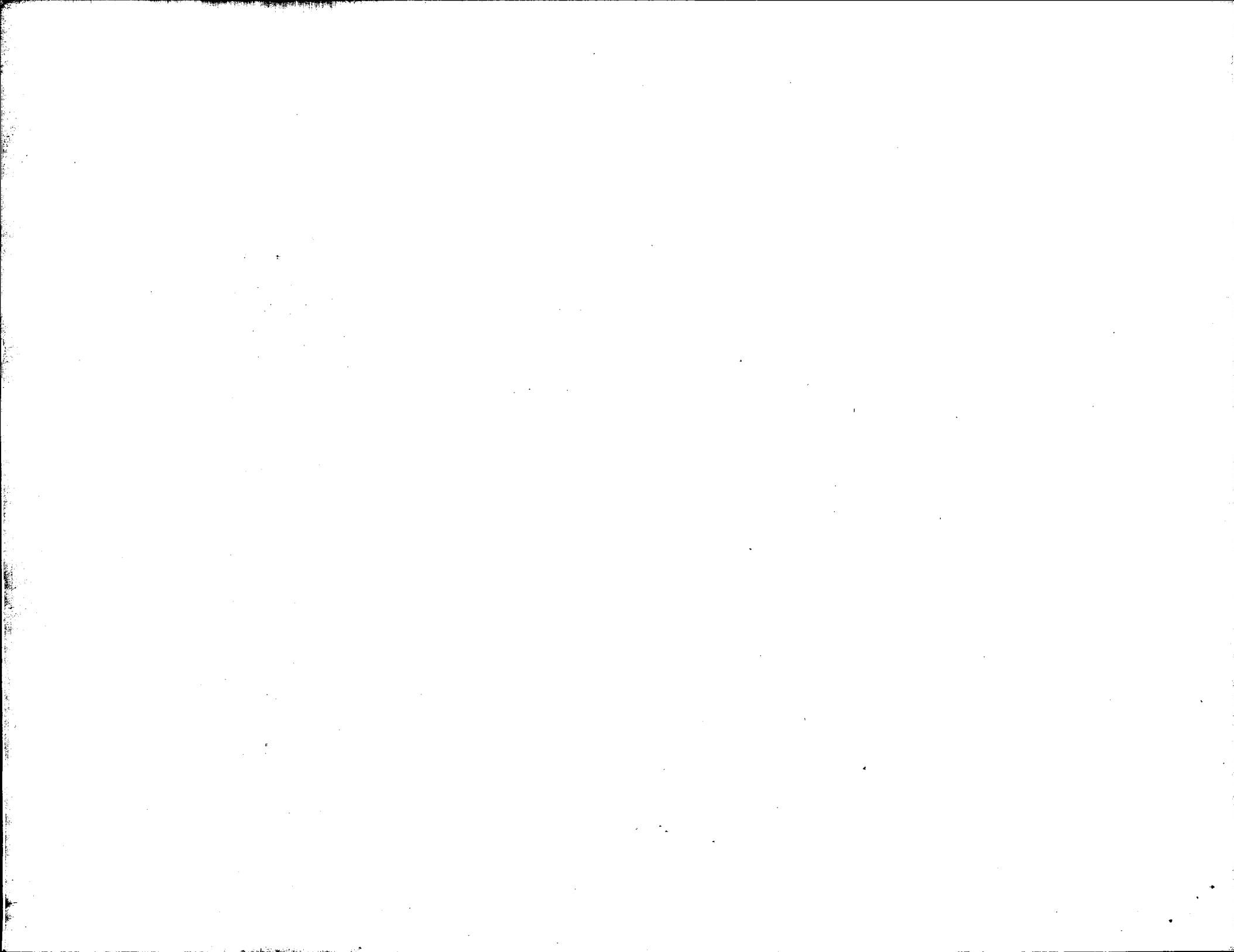
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.441	.440	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.001	8.002	8.000		
F	0.490	0.510		.496	.501	.500	.502		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.376	.378	.378	.378		
I	0.490	0.510		.506	.504	.503	.502		
J	1.174	1.184		1.179	1.179	1.179	1.178		
K	0.558	0.578		.574	.571	.571	.571		
L	1.174	1.184		1.179	1.179	1.179	1.178		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	4.119	4.129		4.127	4.122	4.124	4.123		
P	0.115	0.135		.125	.124	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.249	.249	.250		
S	0.115	0.135		.125	.127	.129	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.227		
V	0.230	0.250		.240	.238	.240	.239		
W	0.115	0.135		.125	.126	.126	.131		
X	0.307	0.312		.310	.311	.310	.310		
Y	0.760	0.765		.760	.761	.766	.760		
Z	0.352	0.372		.365	.365	.365	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.626	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.248	.247	.248		
AE	1.500	1.520		1.513	1.513	1.513	1.513		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.248	.248	.249		
AI	2.000	2.020		2.003	2.003	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: SP / QML
Date: 08/03/18

Audited by: S.P
Date: 08/03/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SP / QML



DART AEROSPACE LTD	Work Order:	37285
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

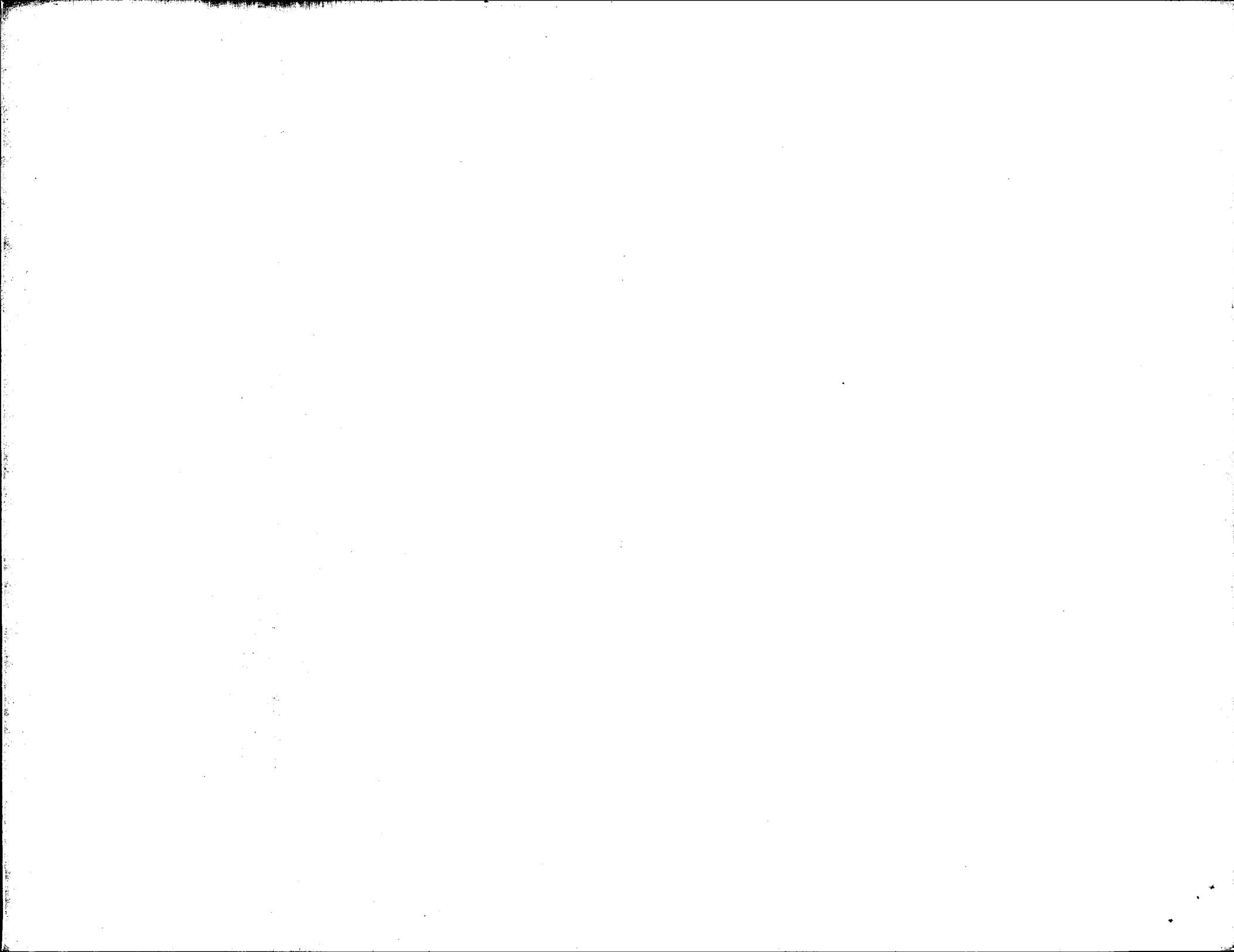
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

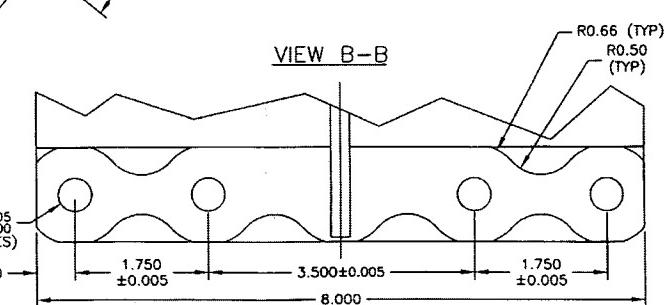
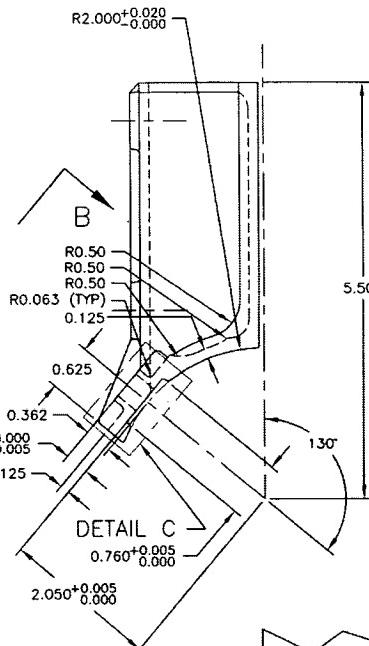
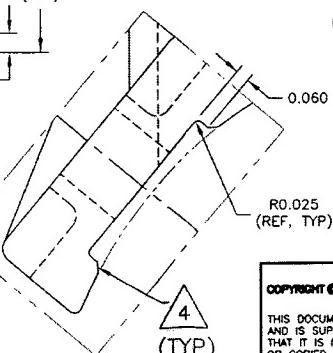
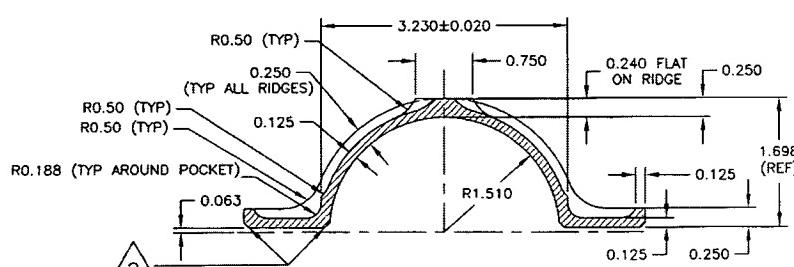
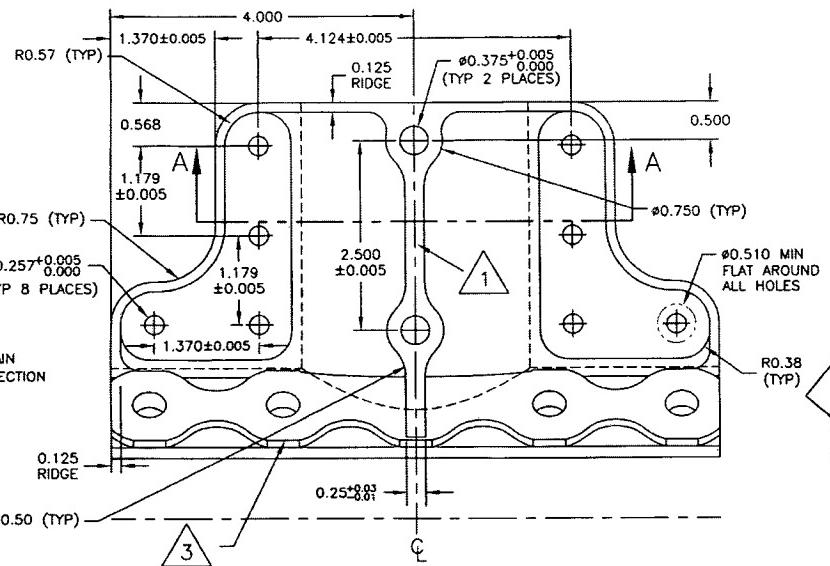
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.002	8.002	8.002		
F	0.490	0.510		.504	.504	.503	.502		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.503	.505	.503	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.369	1.370	1.370		
N	2.495	2.505		2.500	2.499	2.499	2.500		
O	4.119	4.129		4.124	4.124	4.123	4.124		
P	0.115	0.135		.124	.124	.125	.123		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.249	.249	.246		
S	0.115	0.135		.129	.126	.130	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.226	3.236	3.230	3.230		
V	0.230	0.250		.239	.233	.236	.237		
W	0.115	0.135		.129	.124	.126	.132		
X	0.307	0.312		.310	.310	.310	.309		
Y	0.760	0.765		.761	.760	.760	.760		
Z	0.352	0.372		.367	.357	.358	.371		
AA	0.470	0.530		.506	.500	.500	.500		
AB	0.615	0.635		.628	.630	.630	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.244	.249	.245		
AE	1.500	1.520		1.511	1.519	1.511	1.509		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.249	.244	.246	.247		
AI	2.000	2.020		2.002	2.007	2.002	2.006		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: *Am*
Date: 08/03/17

Audited by: *8-1*
Date: 08/03/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i> <i>JL</i>	





E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
DS	PH	REV. E
CHECKED	APPROVED	DRAWING NO.
		D2574
DATE		SHEET 1 OF 1
05.07.13		SCALE
		2:3
		TITLE
		INNER AFT SADDLE

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